

# Work Order ID 72603

Wednesday, August 03, 2011 1:04:17 PM

Page 1

Item ID: D4004-5

Accept

Revision ID:

Item Name: Bottom Strap Attach Bracket

Start Date: 8/3/2011 Start Qty: 6.00

Required Date: 8/8/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-08-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4004

A

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-5 detail of dwg D3033

Ensure cut is started at correct place per dwg

Batch: B52045

2-Deburr

105

0.00



Small Fab

Memo

0.00

Small Fab

Drill and c'sink holes as per dwg and trim part to length as required.

Ac 11-08-04  
11/08/04

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D4004-5

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Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

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Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 6.00



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 woslos

(46)

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

8

8 11/08/11

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11/8/11 (6)

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Item ID: D4004-5

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Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 8/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Identify as per dwg & Stock Location: 106

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/05 (6)

CK 11/08/05

11-08-05 (6)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, August 03, 2011 1:04:23 PM

Page 1

Work Order ID: 72603



Parent Item: D4004-5



Parent Item Name: Bottom Strap Attach Bracket

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD  
10.05.17 as per ECN10-562 DD verf:EC  
IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3033-144		Manufactured	No			100	f	27.2232	0.41	2.589474			
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Seat Track



JB 4602/03

Location

Loc Qty

Loc Code

ST489A

27.22315811

30209

0.5

58045

8.19684211

68524

18.526316

3

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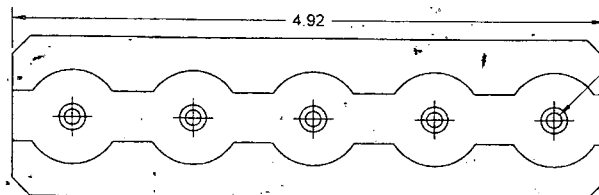


DART AEROSPACE  
PART NUMBER

JOHN CAMERON AVIATION  
PART NUMBER

D4004-5

JCA-M47-2-23



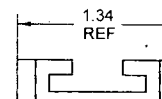
4.92

DRILL Ø0.129 (#30 DRILL)  
CONCENTRIC WITH SEAT TRACK  
CSK Ø0.225 X 100°  
5 PL

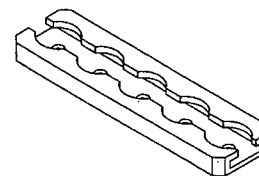
CHAMFER 0.15 X 45°  
TYP



0.37  
REF



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72603



11083

**D4004-5 BOTTOM STRAP ATTACH BRACKET**

RELEASED  
2010-05-05

**NOTES:**

- 1) MATERIAL: MADE FROM ANCR4 P/N 40456-11-144  
OR BROWNLIN P/N 20276-144-0-0  
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DATE	DRAWING NO.	REV. A
MFG. APPR.	10.02.10	D4004	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SIDE RESTRAINT	NTS
<small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

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